



CAL Document Change Notification

DCN No.
7650-DCN-0043-01

CHANGE TITLE: Updates To Cal Pem Mechanical Structure Assembly Drawing

Internal External

ORIGINATOR: Paul Dizon

DATE: 26-Apr-04

NEXT ASSY: N/A

DOC or DWG NUMBER	TITLE	AFFECTED REV.	NEW REV.
LAT-DS-01230	CAL PEM Mechanical Structure Assembly	02	03

CHANGE DESCRIPTION:

- 1) Added Item 8 to the List of Materials table:

REQD: AR

ITEM: 8

PART NO: NSN-8030-00-163-5792

DESCRIPTION: VIBRATITE THREAD LOCK ADHESIVE

- 2) Modified all symmetry tolerance from 0.2 mm to 0.4 mm (page 2, Zone B-3 and Zone C-2)

- 3) Modified perpendicularity tolerance from 0.1 mm to 0.2 mm (page 2, Zone B-3)

REASON FOR CHANGE:

Thread lock adhesive is required to secure the Close-Out Plate Nuts. Assembly of the FMA PEM Mechanical Structure revealed that tolerances can be opened to make assembly of future structure easier. Increasing these tolerances does not violate the stay clear zone specified in the IDD (LAT-DS-00233-07).

DISPOSITION OF HARDWARE:

No hardware affected

Serial numbers affected: 102 - 116

Effective date: 26-Apr-04

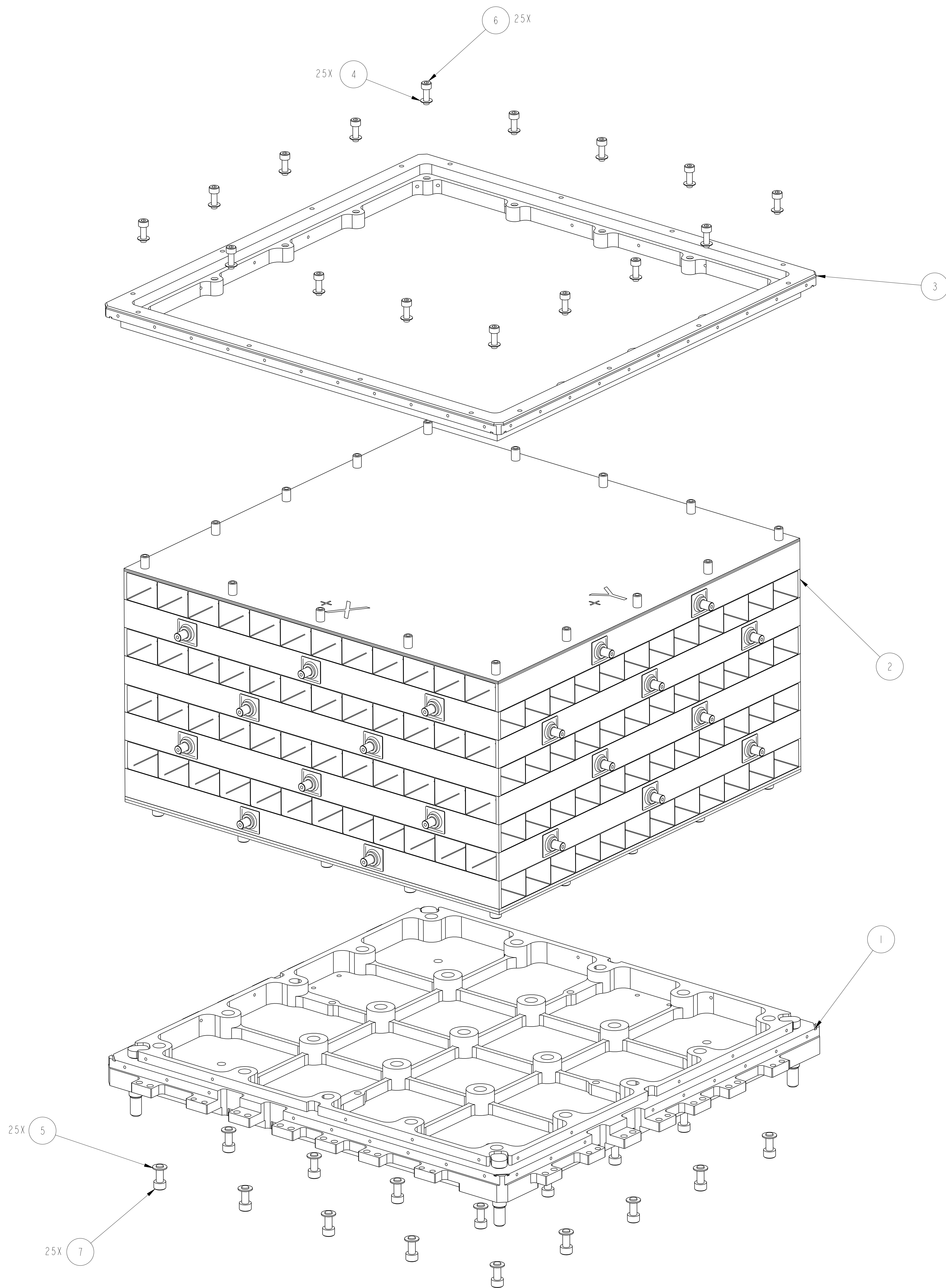
	Use as is	Retest	Rework	Scrap	Other/Comment
Raw material					
Parts in process					No Affect
Assemblies					

APPROVALS		DATE	OTHER APPROVALS (specify):	DATE
ORIGINATOR:	<i>P. Dizon</i>	29-Apr-04	:	
SUBSYSTEM MANAGER:	<i>P. Dizon</i>	29-Apr-04	:	
PROJECT MANAGER:	<i>W.C. Raynor</i>	29-Apr-04	:	
QUAL ASSUR. MANAGER:	<i>J. W. Lee</i>	29-Apr-04	:	
CONFIGURED AND RELEASED:	<i>P. Sandora</i>	29-Apr-04		



2. TORQUE SPECIFICATION:
MJ4 X 0.7 = 4Nm
MJ5 X 0.8 = 5.5 Nm

REVISION				
SYM	ZONE	DESCRIPTION	DATE	APPROVAL



SCALE 0.750

**MASTER
DRAWING**

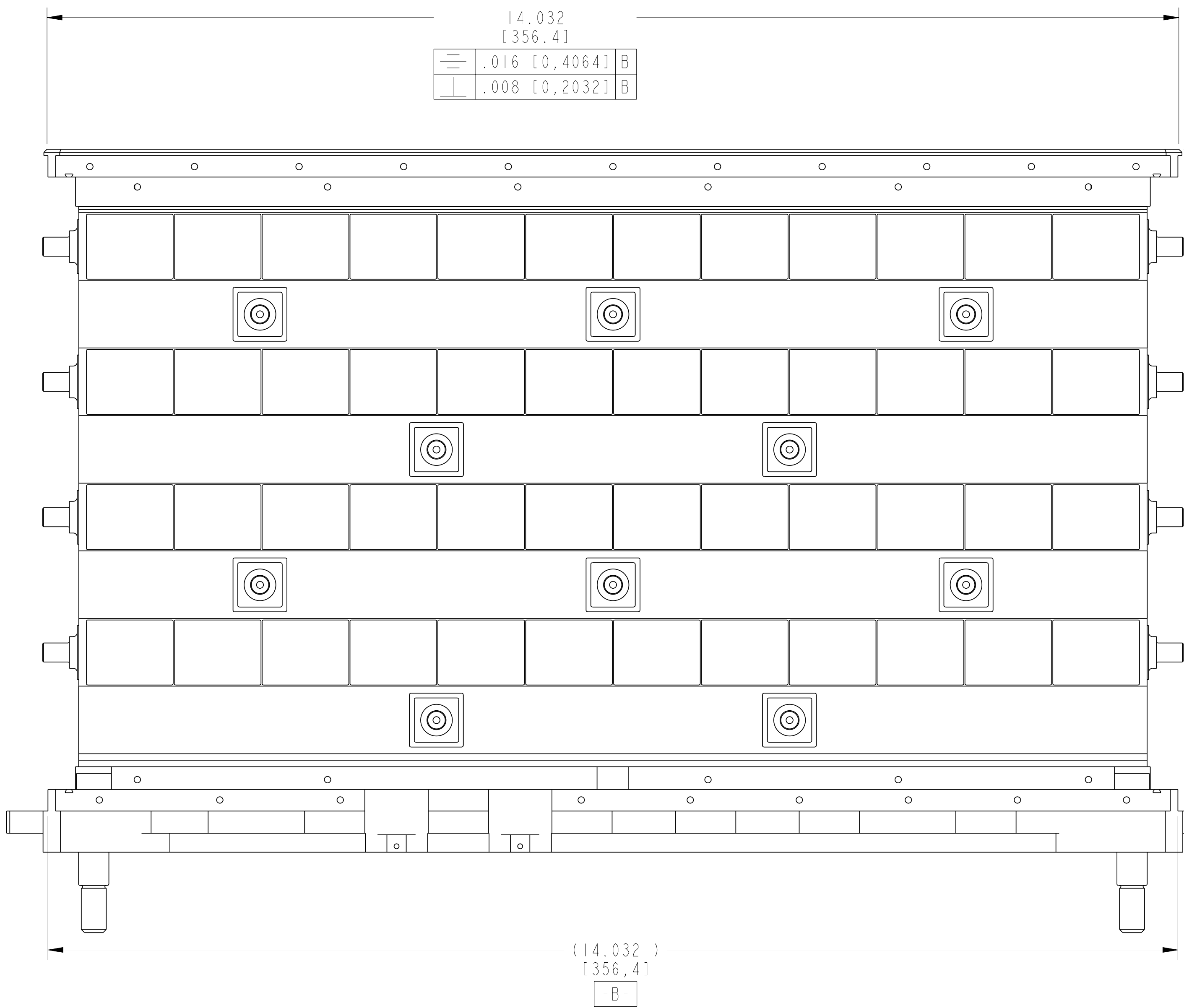
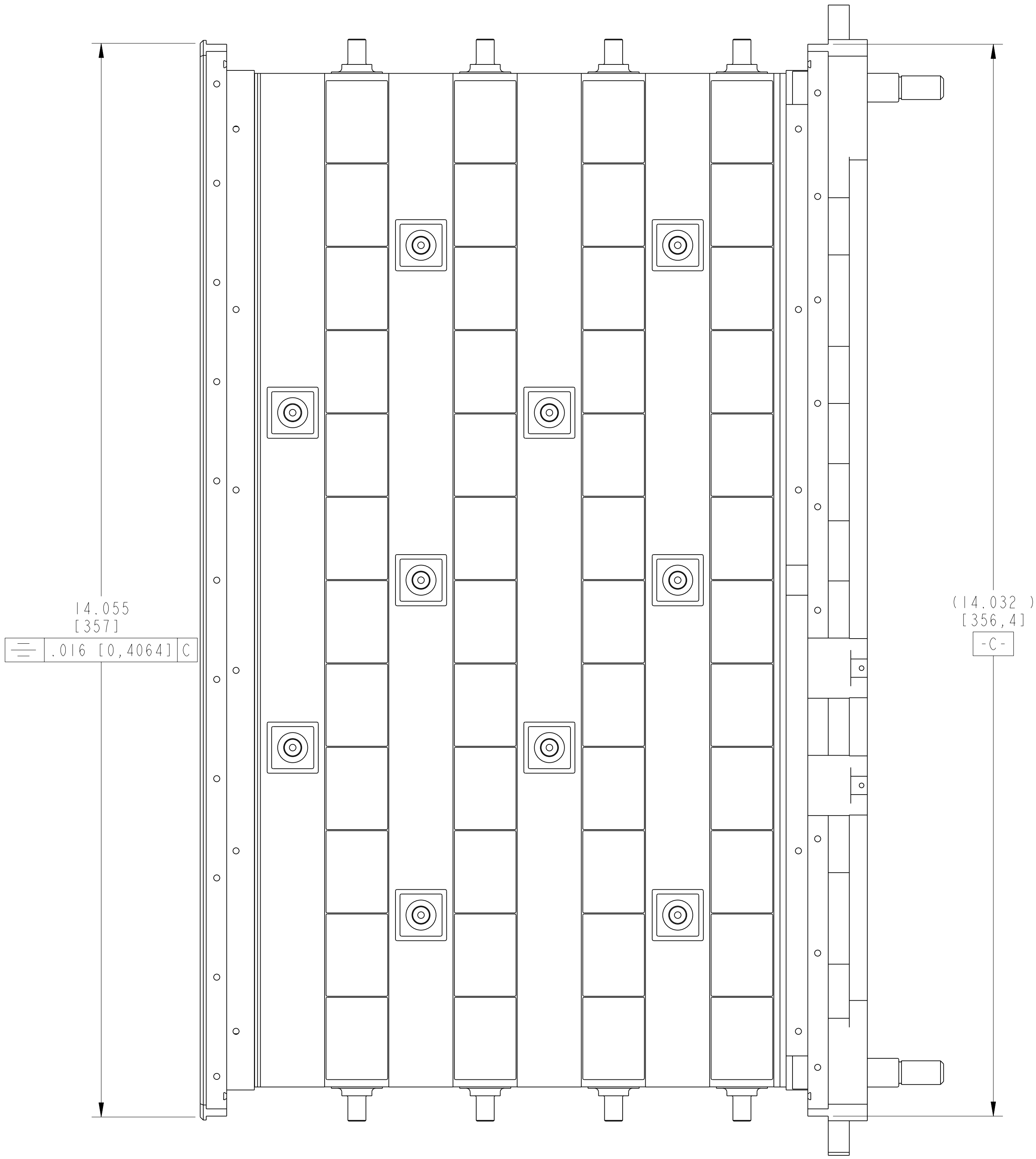
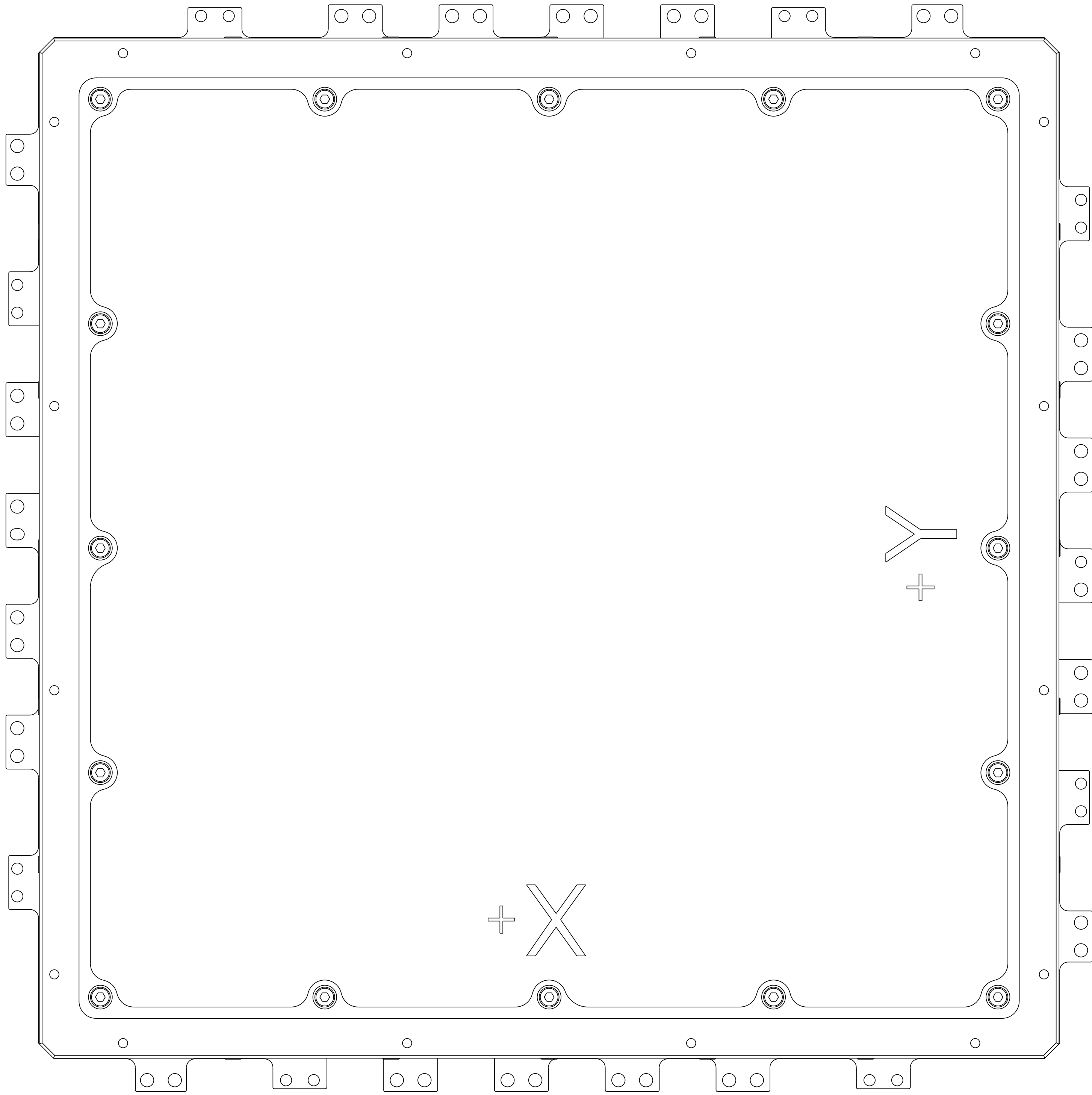
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FOR
MANUFACTURE**

29 APRIL 2004

[illegible]

REVISION				
SYM	ZONE	DESCRIPTION	DATE	APPROVAL



14.055
[357]
=.016 [0,4064] C

14.032)
[356,4]
-C-

14.032
[356,4]
=.016 [0,4064] B
=.008 [0,2032] B

// .016 [0,4064] C

8.240 MAX
[209.3 MAX]

-A-

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MANUFACTURE
29 APRIL 2004

NAME	INIT	DATE	CAGE CODE	LAT-DS-01230			REV
CHECKED	PVD	4/29/04		SCALE	WT	SH	02
APPROVED-ENGR	PVD	4/29/04	FILE NAME: LAT-DS-01230 .	MODEL NAME: LAT-DS-01230 .			